

## MANUFACTURE OF RUBBER STOPPER FOR VIAL

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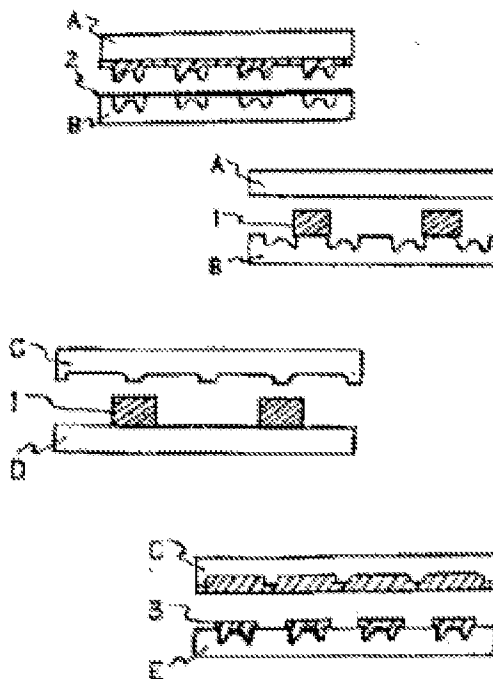
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### Abstract of JP3270928

**PURPOSE:** To contrive to reduce the incidence of defective article by a method wherein stock stoppers, the shape of each of which is the leg shape of a rubber stopper, and formed by thermally pressing bar-like green rubber ribbon with a multicavity mold and combined with semi-vulcanized rubber sheet, which is separately formed in the top face shape of the rubber stopper, and, after that, heated in a mold under pressure. **CONSTITUTION:** Bar-like green rubber ribbons 1 are placed between molds A and B so as to be vulcanized under heat and pressure for one-tenth to one-half of the required vulcanizing time. After that, the molds are opened under the state that the resultant semi-vulcanized rubber sheet is stuck to the upper mold A and synthetic resin film 2 is placed on the surface of the lower mold B so as to close both the molds in order to vulcanize the sheet for the remainder of the required vulcanizing time. The obtained molded sheet is blanked in order to obtain stock stoppers, each of which corresponds to the leg part of a final product. On the other hand, bar-like green rubber ribbons 1 are placed between an upper mold C, which has the top face shapes of respective rubber stoppers, and a flat plate-like lower mold D so as to vulcanized under heat and pressure for one-tenth to one-half of the required vulcanizing time. After that, the lower mold D is exchanged with a lower mold E, on which stock stoppers corresponding to the leg part of the rubber stopper are charged, so as to be vulcanized successively under heat and pressure for the remainder of the required



vulcanizing time in order to obtain products by  
removing flash which is developed in the  
periphery of each stopper.

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